

S232212



P/N: D6202

REV: A

SERIAL: S232212

NOV 10 2019

INSP/DATE

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6202

Job Sheet 202210



D6202

I-Beam Extrusion



0 lbs

10/22/19

Job Qty: 25 ft

Status: New

Priority: Medium

Job Tracking No:

Created By: Chantal Lavoie

Description:

Due Date: 11/14/19

Type: Stock

Note: DWG REV A

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Purchasing - Ft	25 ft		11/14/19	0.00	0.00	Purchasing - 1		
	OCT 25 2019						Purchasing - 2		
	DAS 13 9-89						Purchasing - 3		
									NOV 15 2019
110	Packaging 2-1 - Receive - B4B	25 pcs		11/14/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



Container No: S232212



Part: D6202

Job No: 202210

Serial No/Batch: S232212

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/16/19

Plex 10/22/19 11:01 AM Dart.Lavoie.Chanta

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 6-18	25 pcs	11/14/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
130	Packaging 3-1 - Stock - B4B	25 pcs	11/14/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B

					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA FT	25 ft	11/14/19	0.00 0.00	QC 21 - SA - 21	DAS 21 NOV 19 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Purchasing)
 Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 130 - (Identify as per dwg & Stock Location:_____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6202P	I Beam Extrusion	25 ft (1 ea)	100-Purchasing - Ft	5232147

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D6202P	25	0	0

Part Specifications

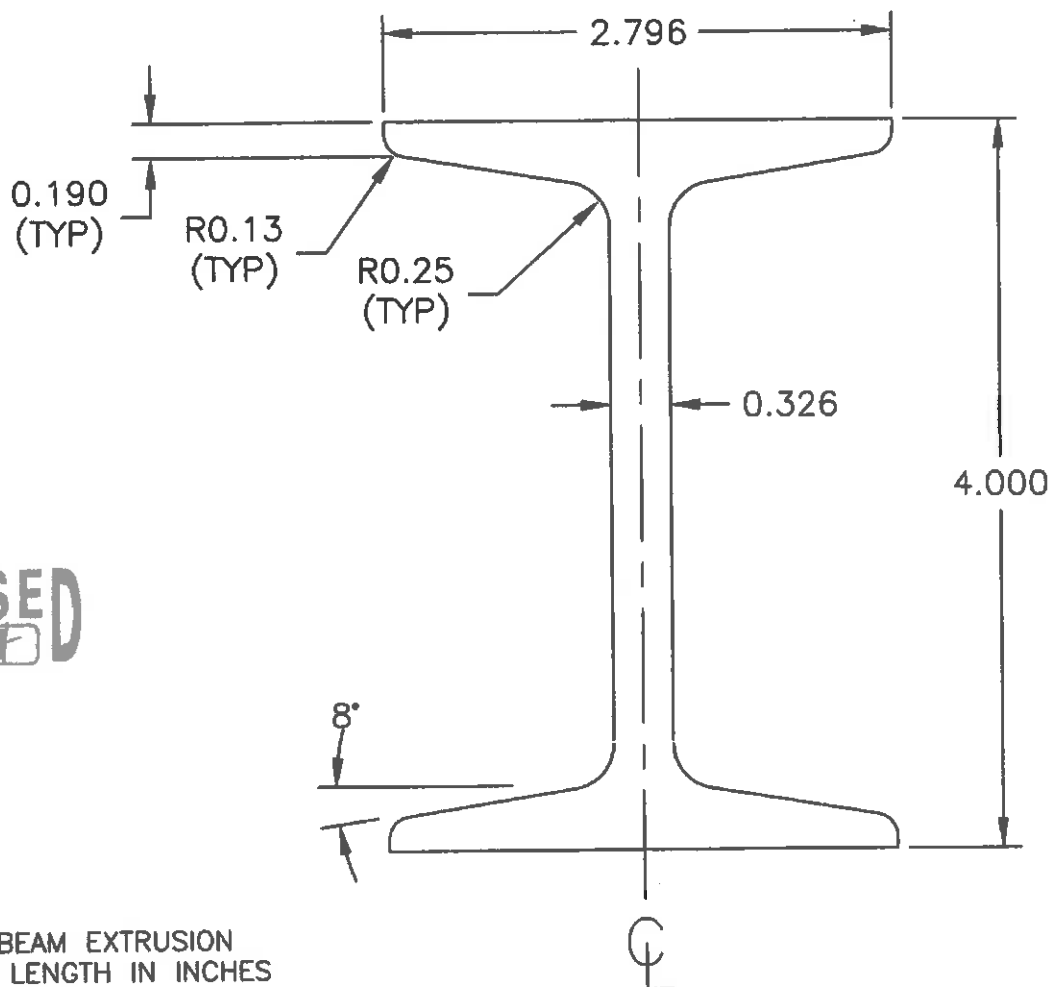
Specifications could not be found.

Plex 10/22/19 11:01 AM Dart.Lavoie.Chantal



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6202	REV. A SHEET 1 OF 1
DATE 01.04.02		TITLE I-BEAM EXTRUSION	SCALE 1:1
A	01.04.02	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



RELEASED
01.04.09 *[Signature]*

D6202-XXX I-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6202-027 IS 27 INCHES LONG

PURCHASE MATERIAL: AMERICAN STD. I-BEAM
4.000" x 2.796" x 0.326" THICK
6061-T6/T651 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Service Center Metals
5850 Quality Way
Prince George, VA 23875

Can Be.

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

OUR ORDER NUMBER	ITEM
992356	31



ASTM-B308-10 SPOT STENCIL

CALL TO

SAP TO

MANIFEST NUMBER

410231

CUSTOMER PO

P80730CG020

CUSTOMER PART NUMBER

Y-1723

14 pcs

1,150 lbs

Quantity Certified

DATE OF SHIPMENT

8/7/2019

SALES PERSON

Ellis Williams

CUS NUMBER

BS0291

ALLOY/TEMPER

6061-T6

DESCRIPTION

ASI 4.000x2.796x.326

SPECIFICATION

ASTM-B221-14

SPECIFICATION

SAE AMS-QQA-200/8A Stabilized

SPECIFICATION

ASME SB-221

We hereby certify that the material covered by this report has been inspected in accordance with the most exact certification procedures, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material meet the mechanical properties shown. Same produced and certified as per 1061-T6511 also meet the requirements of 6061-T6.

All aluminum products supplied by Service Center Metals, LLC comply as specified (unless noted). Neither we nor our suppliers are liable for the manufacture of aluminum products at our facility. Furthermore, aluminum products supplied by Service Center Metals here and, to the best of our knowledge, conform to any standards of industry.

This product is RoHS-2, REACH, and DPAPS compliant.

SCM is ISO 9001-2015 certified

Mechanical Properties

Tests Lot No.

1 201915452

Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
8/7/19	min 43.00 max 43.00	min 40.30 max 40.30	min 19.00 max 19.00

CERTIFIES THAT
THIS IS A TRUE COPY OF THE ORIGINAL
MILL TEST REPORT NOW ON FILE
RECEIVED AND INSPECTED

AUG - 9 2019

BY: *Calvin J. Wiggins*

Theriana Lim, Certification Processor

DAS
81
9-89

B112830 R789250.

Chemical Composition for Aluminum Alloy 6061

Cast #	Lot No.	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al	Others		Melt Source
												Each	Total	
002K190801B	201915452	6061	0.63	0.27	0.21	0.07	0.88	0.07	0.05	0.03	97.61	0.05	0.15	United States of America

SCM products are melted and extruded in the USA

Print Date: 8/7/2019

Calvin J. Wiggins, Director of Quality & Technical Services

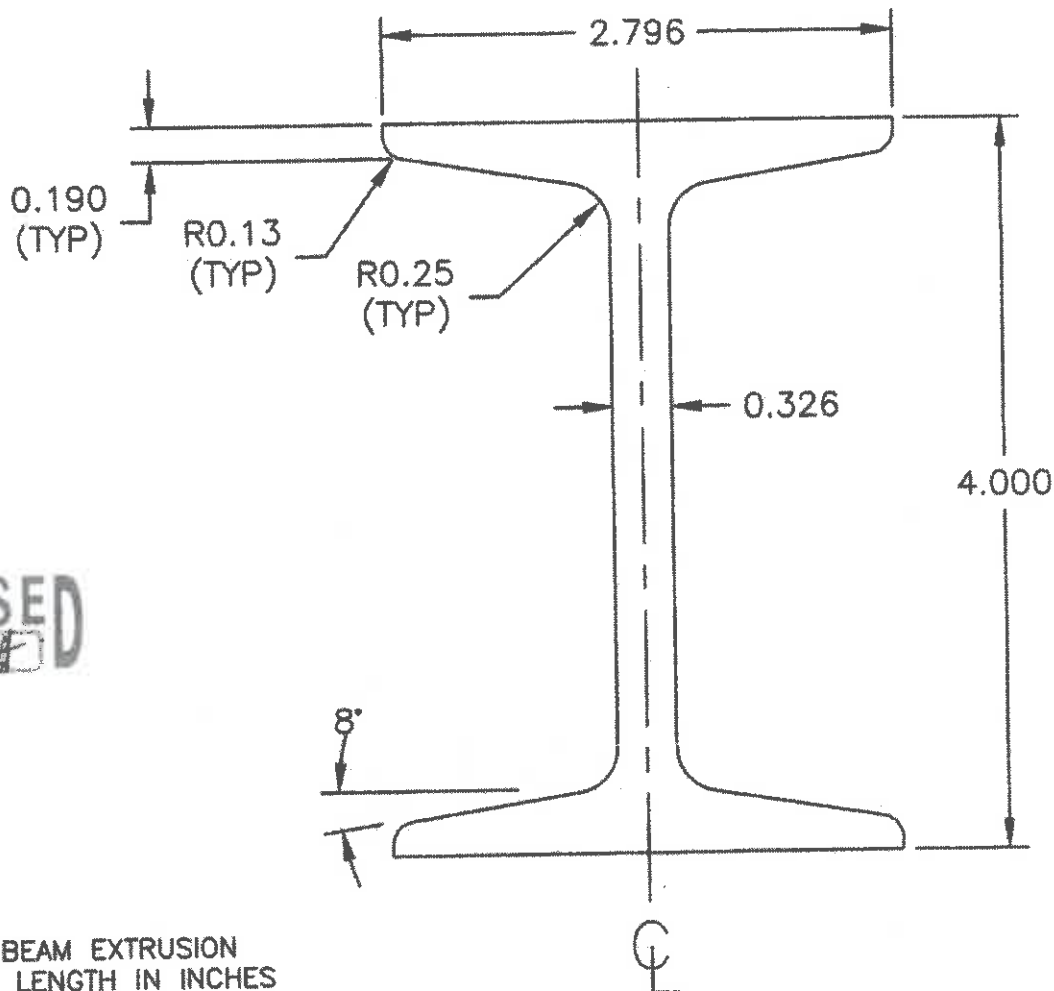
Rev 8/1/2019

LINE 2 603
D6202



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D6202	REV. A SHEET 1 OF 1
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SPECIFICATION CONTROL DRAWING



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EG.
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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6202
DATE: NOV 15 2019

PO / BATCH NO.: P04B044901 / 5232147

MATERIAL CERT REC'D: YES
QUANTITY RECEIVED: 25 ft
QUANTITY INSPECTED: 25 ft
QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.326
THICKNESS RECEIVED: 0.326
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	QQ-A-200/8
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HT 201915452
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>[Signature]</u>	DAS 81 9-89	SIGNED OFF BY: _____	
DATE: <u>NOV 15 2019</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remlt to be scanned and received in